

OB1 - <offline>
"
Name:
Author:
Family:
Version: 0.1
Block version: 2
Time stamp Code: 12/27/2015 06:57:37 AM
Interface: 02/15/1996 04:51:12 PM
Lengths (block/logic/data): 00584 00436 00026

Name	Data Type	Address	Comment
TEMP		0.0	
OB1_EV_CLASS	Byte	0.0	Bits 0-3 = 1 (Coming event), Bits 4-7 = 1 (Event class 1)
OB1_SCAN_1	Byte	1.0	1 (Cold restart scan 1 of OB 1), 3 (Scan 2-n of OB 1)
OB1_PRIORITY	Byte	2.0	Priority of OB Execution
OB1_OB_NUMBR	Byte	3.0	1 (Organization block 1, OB1)
OB1_RESERVED_1	Byte	4.0	Reserved for system
OB1_RESERVED_2	Byte	5.0	Reserved for system
OB1_PREV_CYCLE	Int	6.0	Cycle time of previous OB1 scan (milliseconds)
OB1_MIN_CYCLE	Int	8.0	Minimum cycle time of OB1 (milliseconds)
OB1_MAX_CYCLE	Int	10.0	Maximum cycle time of OB1 (milliseconds)
OB1_DATE_TIME	Date_And_Time	12.0	Date and time OB1 started

Block: OB1 **"Main Program Sweep (Cycle)"**

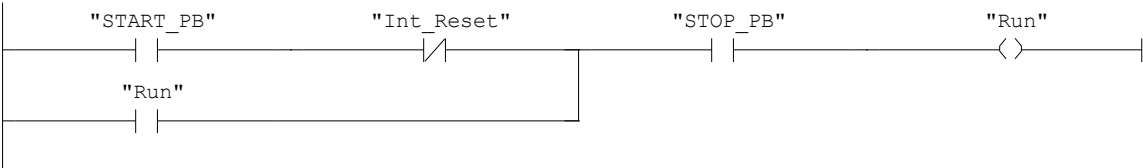
Copyright (c) 2011, 2015 Dogwood Valley Press, LLC

Problem SP6-14 Pick-and-Place Machine Control

Additional internal memory:
Symbol Address
Run M5.0 BOOL On while station running
Int_Reset M5.1 BOOL Internal reset
Step_1 to Step_10 M0.1 to M1.2 BOOL Step-in-progress bits
Clamp_Tmr DB1 SFB4 Times clamping
Unclamp_Tmr DB3 SFB4 Times unclamp
Reset_Tmr DB4 SFB4 Times unclamp during reset

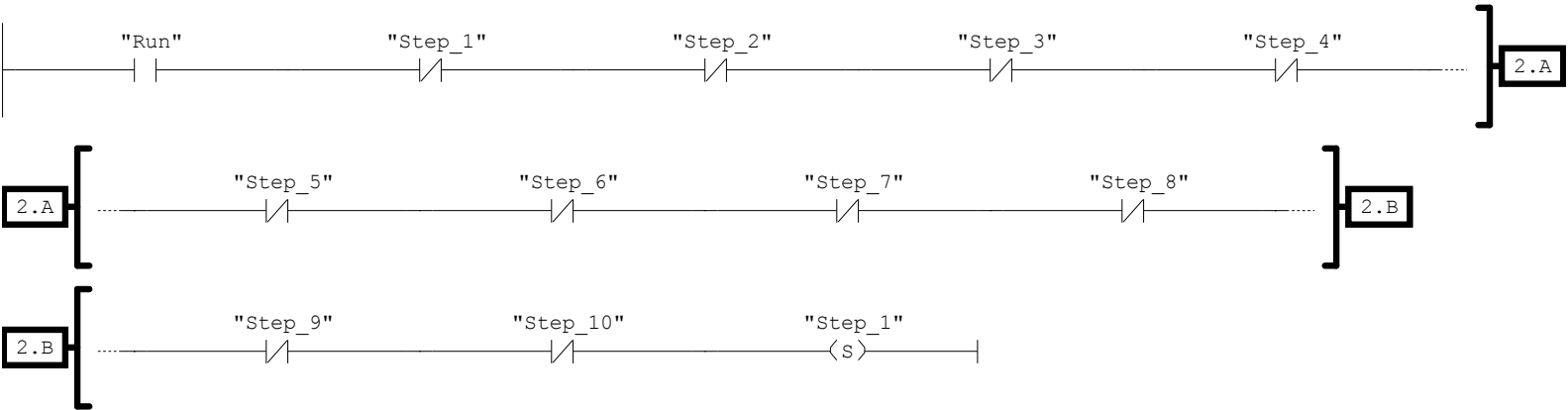
Network: 1 Start/stop

During reset prevent start



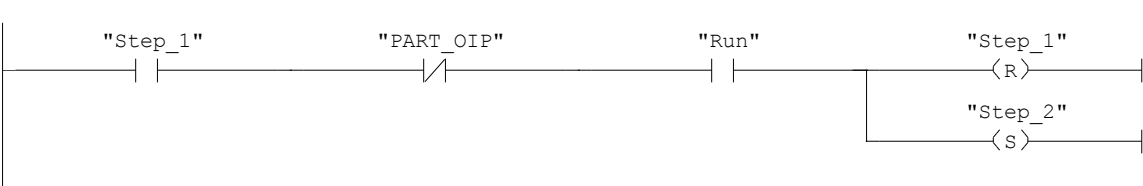
Network: 2

Initial start



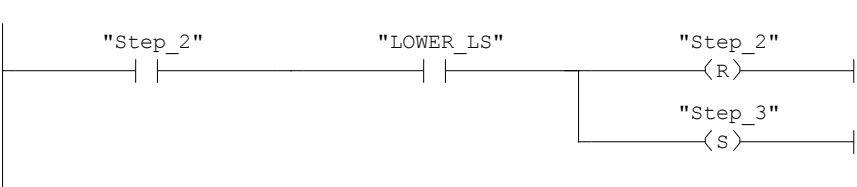
Network: 3

Step 1 Wait for part ready.



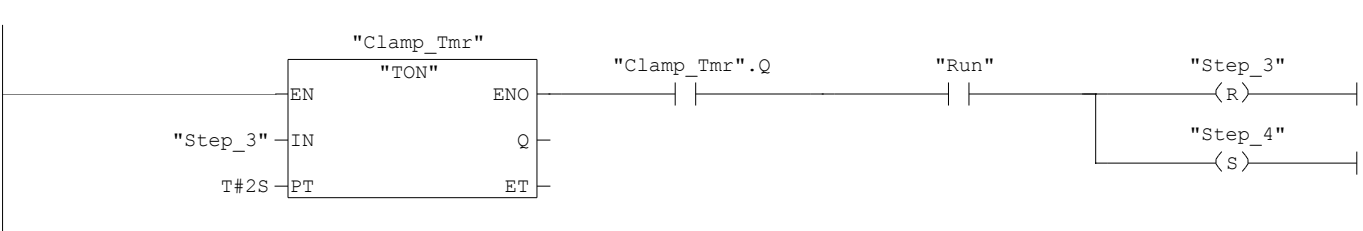
Network: 4

Step 2 Lower to left table



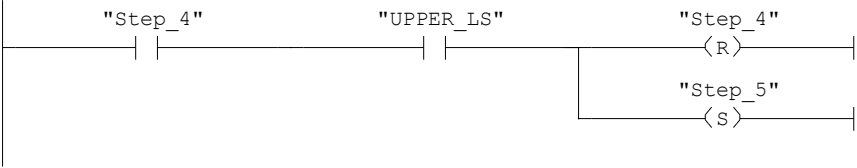
Network: 5

Step 3 Clamp part



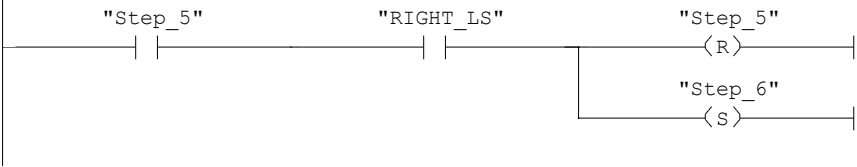
Network: 6

Step 4 Raise to home



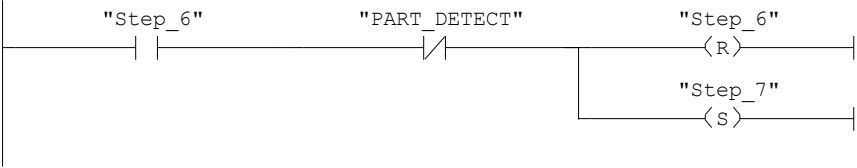
Network: 7

Step 5 Move to right



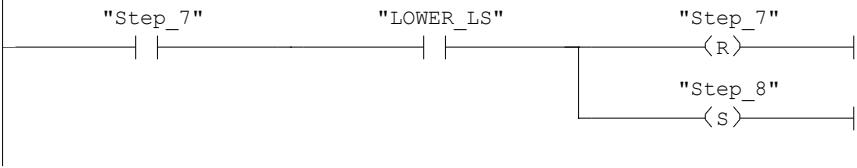
Network: 8

Step 6 Wait for part removed



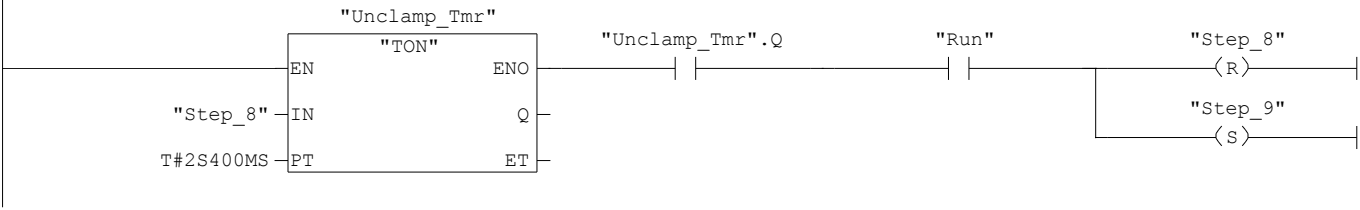
Network: 9

Step 7 Lower to right table



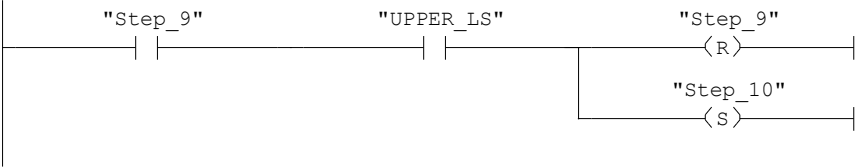
Network: 10

Step 8 Unclamp



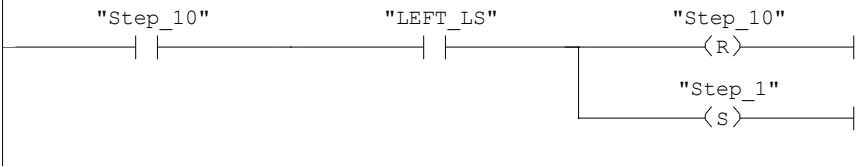
Network: 11

Step 9 Raise



Network: 12

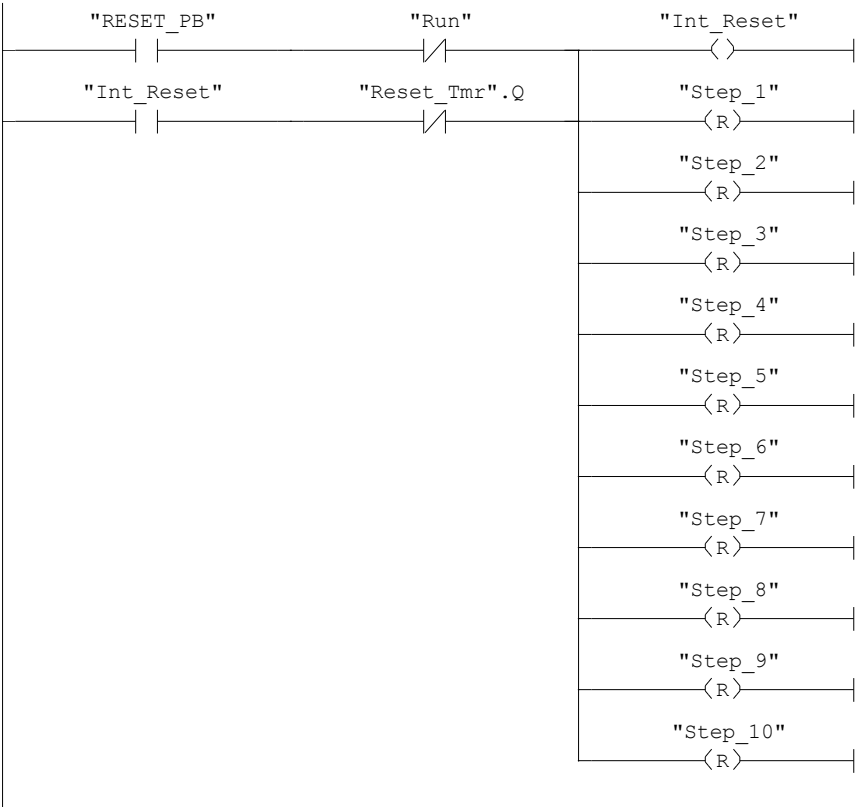
Step 10 Move to left



Network: 13

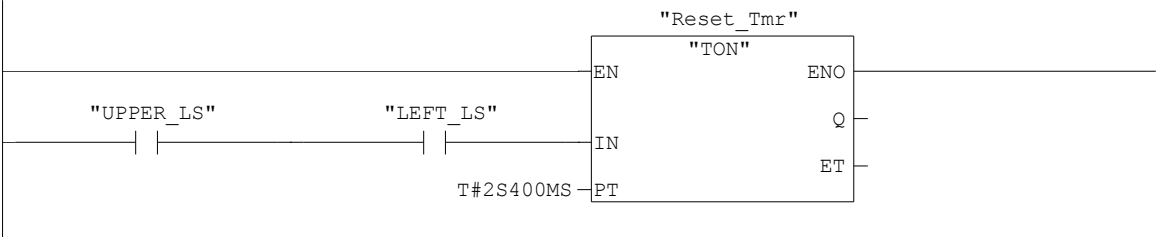
Reset

Keep internal reset on while cylinders are not retracted.



Network: 14

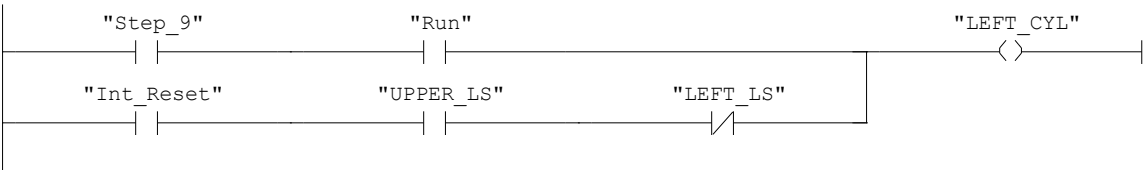
Reset timer



Network: 15

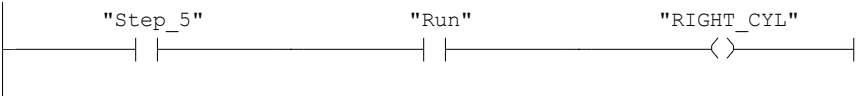
Left cylinder control

When reset, do not move until fully up.



Network: 16

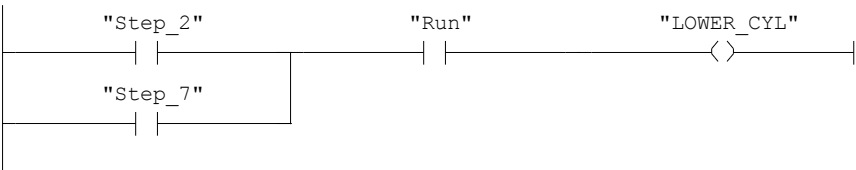
Right cylinder control



Network: 17

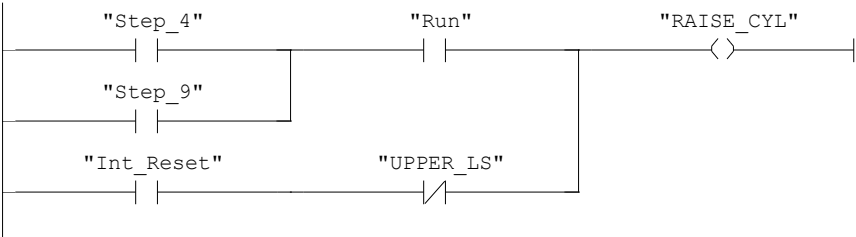
Lowering cylinder control

Retract on reset



Network: 18

Raise cylinder control



Network: 19	Clamp cylinder control
Maintain clamp while moving home during reset.	

